

day, 05/05/2008 11:11:50 AM  
a Lacelle

## Process Sheet

Customer Number	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE	
Estimate Number	: 39032		Part Number	: D37851	
P.O. Number	: 13296		Drawing Number	: D3785 PRELIM	
This Issue	: 05/05/2008 S.O. No. :		Project Number	: N/A	
Prsh Rev.	: NC		Drawing Revision	: PRELIM 08.05.21	
First Issue	: / /		Material	:	
Previous Run	:		Due Date	: 08/05/2008 Qty: 2 Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:A 08-05-01 new issue DD verified by:EC				

## Additional Product

FOR ENGINEERING USE

## PROTOTYPE

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304TS1250W120	304 SQ Tube 1.250x1.250x.120w  M6061 T6 TS 1250W120
		Comment: Qty.: 1.0542 f(s)/Unit Total : 2.1084 f(s) Batch: M108090 304 SQ Tube 1.250x1.250x.120w 6061-T6 SQ Tube 1.250x.120 FF → FF 08-05-22 batch: M107903 FF 08-05-14
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1  1-cut to lenght as per dwg D3785 FF 08-05-22  2-drill hole one side of tube as per dwg D3785 FF 08-05-14
3.0	QC5	INSPECT WORK TO CURRENT STEP  ENGINEERING APPROVAL  Comment: INSPECT WORK TO CURRENT STEP 08-05-14
4.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Quarantine 08-05-26
5.0	QC21	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE 08-06-04 Prototype

Job Completion



POSITIVE RECALL

EFFECTIVE 08.05.05 AUTH

RELEASED

DATE 08.05.22

MF 08-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3785-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

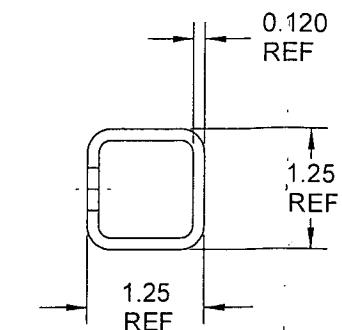
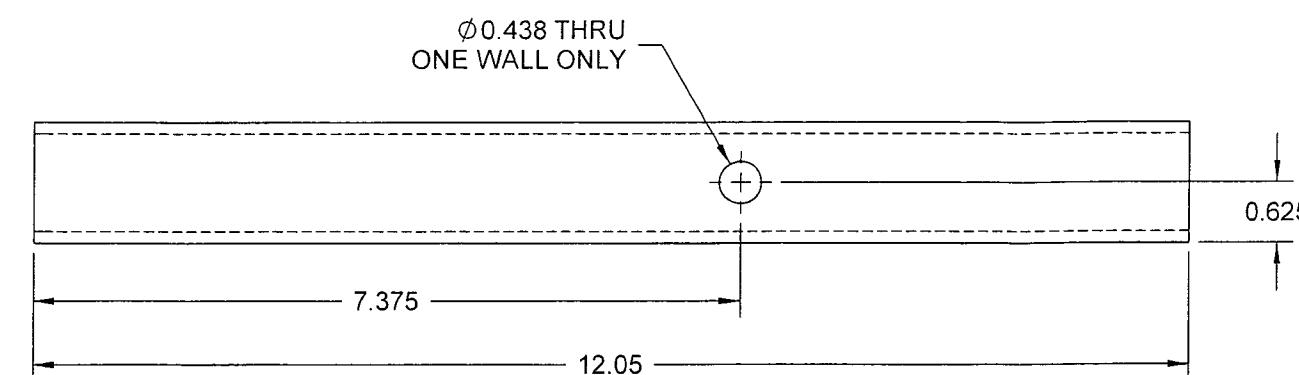
		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22		Scrap due to material chg.  S.S. to Alum 6061T6	Initial 08/05/22	Strap and destroy all parts  Replace with new material chg	08/05/22	08/05/22	08/05/22	08/05/22
				- Replace on this w/o Qty 1 m 108090	FF 08/05/22			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

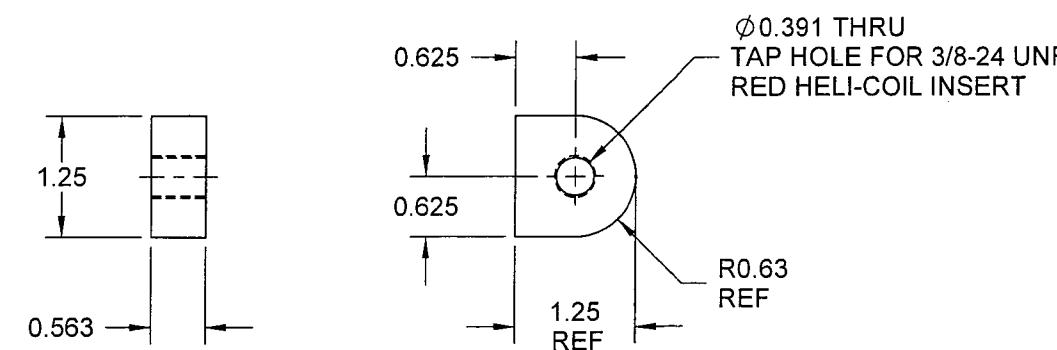
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D3785-1 TUBE

00004A



D3785-5 FIXTURE

**PROTOTYPE  
PRELIMINARY ISSUE**

08.05.21

D3785-1/5 NOTES:

- 1) MATERIAL:
  - D3785-1: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING, 1.25 X 1.25 X 0.120 WALL, PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.250W.120)
  - D3785-5: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: - D3785-1 = 0.59 lbs  
- D3785-5 = 0.25 lbs

DESIGN	<i>1</i>	<b>DART AEROSPACE LTD</b> <small>HAWKESBURY, ONTARIO, CANADA</small>
DRAWN	<i>1</i>	
CHECKED	<i>1</i>	
MFG. APPR.	<i>1</i>	
APPROVED	<i>1</i>	
DE APPR.	<i>1</i>	
DRAWING NO.	<b>D3785</b>	REV. A
		SHEET 3 OF 4
TITLE	<b>ARMREST WELDMENT</b>	SCALE
DATE	<b>08.04.29</b>	NTS
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VR0004

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761Job #: 00224ADate: 08.04.30Product Name: FULL VERTICAL REFERENCE DOORRequested By: BBDesign Manager Approval: MP

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
5	D3701-1F ✓	FLOOR DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3702-1 ✓	FORWARD DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-1F ✓	AFT DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-3F ✓	AFT CORNER DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-5 ✓	AFT CAP	08.04.30	Y	08.05.02	FOR TESTING	
1	D3785-041 ✓	ARMREST WELDMENT	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3785-1 ✗	TUBE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-3 ✓	BRACKET	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-5 ✓	FIXTURE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	

## PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

**Product Name:** FULL VERTICAL REFERENCE DOOR

**Requested By:**

**Design Manager Approval:**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/05/2008 11:11:50 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: TUBE		
Job Number	: 39032			Part Number	: D37851		
Estimate Number	: 13296			Drawing Number	: D3785 PRELIM		
P.O. Number	:			Project Number	: N/A		
This Issue	05/05/2008	S.O. No.	:	Drawing Revision	: PRELIM		
Prsht Rev.	: NC			Material	:		
First Issue	11	Type	R & D SM/MED FAB	Due Date	08/05/2008	Qty:	2
Previous Run	:			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A 08-05-01 new issue DD verified by:EC						

Additional Product

FOR ENGINEERING USE

## PROTOTYPE

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M394TS1250W420 304-SQ-Tube1-250x1-250x120w



M6061 T6 TS 1250x120

Comment: Qty: 1.0542 f(s)/Unit Total: 2.1084 f(s) Batch: m108090 camele p10.6375  
 304-SQ-Tube1-250x1-250x120w 6061-T6 SQ Tube 1-250x120 → FF 08-05-22  
 batch: M107983316271 camele FF 08-05-14

2.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-cut to length as per dwg D3785

FF 08-05-22

2-drill hole one side of tube as per dwg D3785

FF 08-05-14

3.0 QC5 INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

Sodolby 08-05-14

08-05-14

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Quarantine

08/05/26 ②

Location: \_\_\_\_\_

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27 ②

Job Completion



POSITIVE RECALL

EFFECTIVE 08-05-05 AUTHL

CLEARED

DATE 08-05-22

# Receiving Report

Date: 8/1/21  
 Supplier: ACIER CAMPPI  
 Dart P/O: 6375  
 Batch No: M108090

Packing Slip: Yes C No         
 Invoice: Yes C No         
 Receipt: Cash C Cr       

F Please Note Attached: Yes C No        N/A         
 V Aybill Attached: Yes C No        N/A         
 C Shipment Complete: Yes C No        N/A         
 C 36 Inspection: C        N/A         
 V Work Order: C        N/A       

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>M22373502</u>	<u>1/8" FLAT 100' L</u>	<u>96</u>	<u>0</u>	<u>96</u>	<u>0</u>	
<u>M23475573</u>	<u>1/8" SHEET</u>	<u>26</u>	<u>0</u>	<u>26</u>	<u>0</u>	

Initial of receiver (if shipment OK) Level 12

Location       

Production/Admin: 08/05/2022  
 Date Received/Costing RCI 7/29/22  
 Initial C

H:\FORMS\Purchasing\approved purch\RECREPORT Rev

P.T.O. -7

SIGNATURE DU

X

TÉLÉPHONE: 450 37  
 FAX: 450 37

935, boul. du Havre  
 Valleyfield (Québec)  
 J6S 5L1

VENDU À / SOLD TO:

613-632-5200 613-632-1053

DART AEROSPACE LTD  
 1070 ABERDEEN STREET  
 HAWKSBURY,  
 ONTARIO  
 J6A 1K7

EXPÉDIEZ À /

DART AEROSPACE LTD  
 1270 ABERDEEN  
 HAWKSBURY  
 ONTARIO  
 K6A 1K7

VOTRE N° DE COMMANDE / YOUR P.O. N°	VEND. / SALES M.	CODE CLIENT / CUST. CODE	EXPÉDIE PAR / SHIP VIA
6375	D	DAER	
✓ NOMBRE QUANTITY	CODE DE PRODUIT PRODUIT CODE	COMMANDE ORDERED	EXPÉDIÉ SHIPPED
	34212	40	3000
			10/10/22
			ALUM. 2024
			1/8" SHEET
		36	ALUM. 2024 1/8" SHEET
	PGS48166	3	304 18 16
	TAL114114125R	20	1/8" SHEET

\* Unités de mesure: CLB Cent livres • CPI Cent pieds • UN Unité • PI Pieds • PC Pied carré  
 \* Units of measure: CLB Cent pounds • CPI Hundred feet • UN Unit • PI Foot • PC Square foot

## CONDITIONS :

LES MATERIAUX LIVRÉS ET FACTURÉS TELS QUE DÉCRÉTÉS DÉMÉURENT LA PROPRIÉTÉ DE "ACIER CAMPPI INC." JUSQU'À PARFAIT PAIEMENT COMPLET DU MATERIAU. LES RISQUES DE PERTE DU BIEN SONT À LA CHARGE DE L'ACHETEUR. LA GARANTIE DE QUALITÉ DU MATERIAU EST LA MÊME QUE CELLE DU FABRICANT. L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES: NET 30 JOURS DE LA DATE DE FACTURATION, ET TOUT COMPTE IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES PRAIS DE 2% PAR MOIS (24% PAR ANNÉE) QUI ACCEPTE DE PAYER. TOUT DÉFAUT D'EXÉCUTER L'UNE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCLÉANCE DU TERME ET PERMET AU VENDEUR, À SON CHOIX, DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE OU REPRENDRE LE BIEN VENDU. TOUTE RÉCLAMATION DONT ÊTRE FAITE DANS LES CINQ JOURS SUR PRÉSENTATION DE CE DOCUMENT, SUR TOUTE MARCHANDEUSE ENDOMMAGÉE, ALTERÉE OU COUPÉE NE PEUT ÊTRE REPRISÉE. AUCUN RETOUR DE MARCHANDEUSE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. TOUTE MARCHANDEUSE RETOURNÉE EST SUJETTE À DES FRAIS DE MANUTENTION DE 25%.

PRÉPARÉ / PREPARED:        VÉRIFIÉ / VERIFIED:         
 PAR BY:       

LIVRÉ / DELIVERED:        HEURE / TIME:         
 PAR BY:

1113  
18 OCT. 2007



**LONGKOU NANSHAN ALUMINIUM GENERAL FACTORY**

**NANSHAN INDUSTRY ZONE LONGKOU CITY SHANDONG  
PROVINCE CHINA**

**TEST REPORTS**

Order No.: A3038 Test Date: 2007.8.31  
Description of Goods: Square Tube-Rnd.Crn. Alloy /Temper: 6061-T6511  
Standard For Test: ASTM B221-2004 AMS QQ-A-200/8 AMS 4173 -E  
Heat No.: 3599  
Net Weight(lbs): 4173.00 Bundle No.: 309-315  
Size(inch): 1.25 X 1.25 X .120 X 249 Die No.: NSXC107-006

**TABLE OF RESULT DETAIL**

*Tube Carr*

**A. CHEMICAL COMPOSITION**

Test Items		Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Impurities	
Normal Requirements	Min	0.40	/	0.15	/	0.8	0.04	/	/	Each	Total
	Max	0.80	0.7	0.4	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Test Results		0.59	0.12	0.22	0.01	1.01	0.13	0.006	0.006	0.05	0.15

**B. MECHANICAL PROPERTY**

Test Items	Ultimate Strength	Yield Strength	Elongation
Units	KSI(min)	KSI(min)	%
Normal Requirements	38.0	35.0	8
Test Results	46.7	43.0	17

It is hereby certified that the above material is manufactured in compliance with the specified standards and meets the stipulated requirement.

Authorized Department: Quality Test Department

Inspector: *[Signature]*

Quality Manager: Xiaoli Chi

Signature: *[Signature]*

LONGKOU NANSHAN ALUMINIUM  
GENERAL FACTORY

